

Date: Monday, 11/21/2005 9:57:44 AM  
 User: Linda Lacelle

## Process Sheet

W/O SPLIT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 24907-1	
Estimate Number : 10675	
P.O. Number : N/A	Part Number : D3443041
This Issue : 11/21/2005 S.O. No. : N/A	Drawing Number : D3443 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : See comment below	Due Date : 11/28/2005 Qty: 12 Um: Each
Checked & Approved By : See comment below	
Comment : EST REV. A 05.11.17 NEW ISSUE EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D34431	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-1	lug	24938

E 05.11.30

2.0	D34435	Tubing
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-5	Tubing	B24936

C20511123

3.0	D34531	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-1	Clevis	B24734

C20511123

4.0	238805	SS DOWEL PIN 3/4" LONG
-----	--------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	238-805	SS DOWEL PIN 3/4" LONG	m19080

C20511123



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 24907

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Weld assembly as per dwg D3443

MA 05/11/30 2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

EC 05.11.30 1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
1-Mask holes as per dwg D3443

MM 05 12 08 Qty 1 EC  
~~HTA used for testing~~

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HTA EC 05.12.08

9.0

SSPH54AN

SS NOSE HEAVY END BALL PLUNGER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Pick:

Design chg. EC

Qty Part Number Description

Batch

2 238-805 SS NOSE BALL PLUNGER

Batch M19080

10.0

63215K32

Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pick:

Qty Part Number Description

Batch

1 63215K32 Spherical Bearing

Batch M18942

SB 05/12/08 1

AD5  
527

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

SB 05/12/08 1





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 24907

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



*2451200*

Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *425*

*605/1409 (1) 2*

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*545 05/12/01 (1)*

*(1) 05/12/01 (1)*

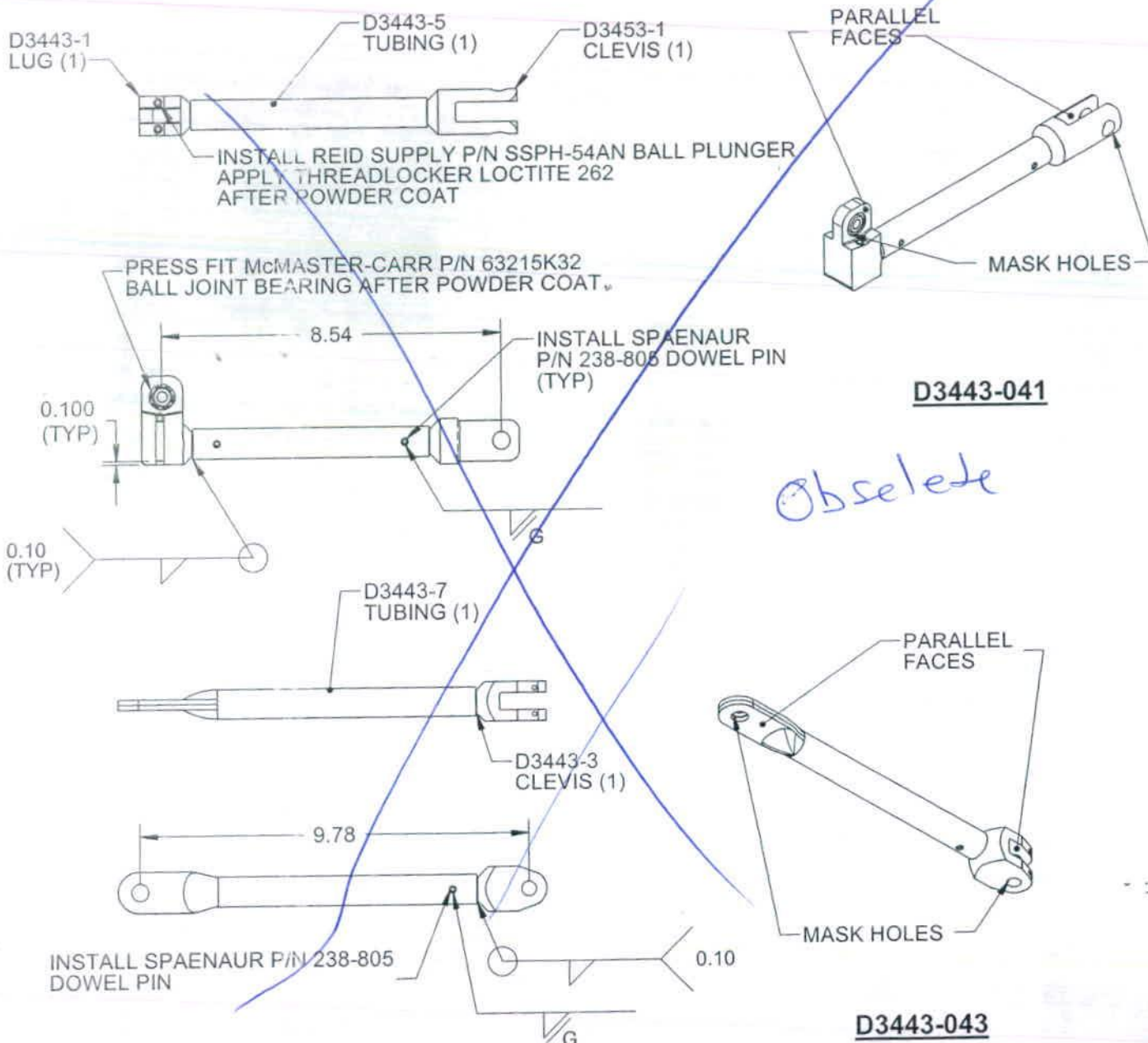
Job Completion





# PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3443	REV. A SHEET 1 OF 3
DATE 05.09.02	TITLE STRUT WELDMENT ASSEMBLY 1:4		
A	05.09.02	NEW ISSUE	



## NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

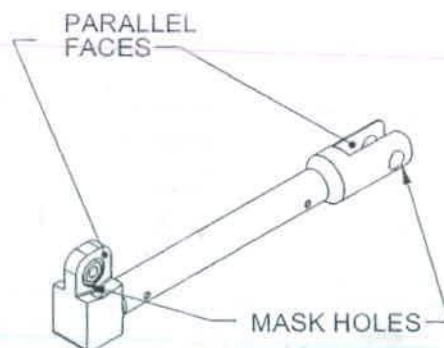
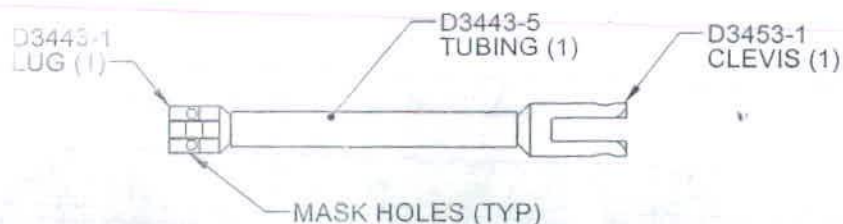
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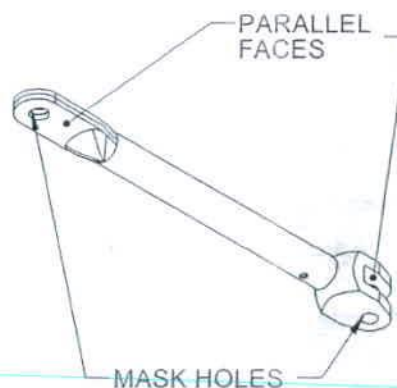
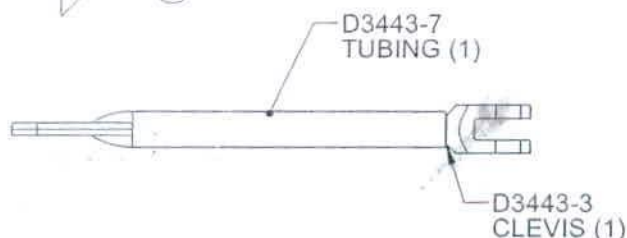
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	



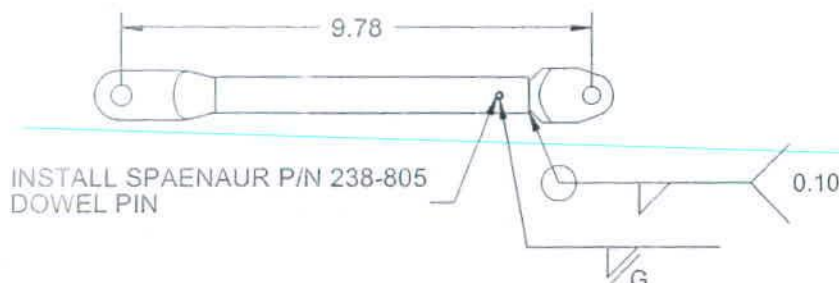
**D3443-041**



0.10  
(TYP)



**D3443-043**



**NOTES:**

- 1) WELD PER DART QSI 004
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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